



Dart Aerospace Ltd.
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D2274

Job Sheet 186493



Part No: D2274

Job Qty: 200 ea

Part Name: Radius Block



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/16/18

Job Tracking No:

Due Date: 11/30/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV F IPP H 00.05.18 Added inspection level 8 EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	200 Ea	11/30/18	11/30/18	0.00	0.00	Start Up Large Fab-7		
105	Waterjet - Flow - 1	200 pcs	11/30/18	11/30/18	0.00	0.00	Waterjet - Flow		SL 18/11/21 FRED 18-11-30 KT 2018-12-02
110	CNC Vertical Machining	200 pcs	11/30/18	11/30/18	0.01	4.79	HAAS 1		
130	QC	200 pcs	11/30/18	11/30/18	0.00	0.00	QC8		
140	Small Fab	200 pcs	11/30/18	11/30/18	0.00	1.08	Small Fab		
150	HandFinish	200 pcs	11/30/18	11/30/18	0.00	0.51	HandFinish1		D.R 18/12/14
160	QC	200 pcs	11/30/18	11/30/18	0.00	0.00	QC7		38
170	Packaging	200 pcs	11/30/18	11/30/18	0.00	0.00	Packaging3	5/000 0107	389
180	QC21-SA	200 Ea	11/30/18	11/30/18	0.00	0.00	QC21		6 9-89

Part Op 105 - CUT BLANK blanks 9.00" long +/- 0.030" Note: 1 blank makes 9 pieces
Descriptions: 110 - Machine as per folio D2274
140 - Tumble Deburr any rough edges after tumbling

DAS
21
9-89

DEC 04 2018

22.0 blanks

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.125	6061-T6 .125 Sheet	16.6000 of (.083 ea) 1.04 (0.0052EA)	90-Start up Operation	90/8009

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.125	17	12	0



Container No: S130330



Part: D2274

Job No: 186493

Serial No/Batch: S130330

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 11/21/18

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Radius Block	0.257inches + 0.005 - 0.000	0.262 0.257		
2	Radius Block	0.750inches ± 0.010	0.760 0.740		
3	Radius Block	0.375inches ± 0.010	0.385 0.365		
4	Radius Block	0.125inches ± 0.010	0.135 0.115		
5	Radius Block	0.750inches ± 0.010	0.760 0.740		
6	Radius Block	0.063inches ± 0.010	0.073 0.053		

Plex 11/21/18 12:27 PM dart.lacelle.linda

